

# Work Order ID 64024

Tuesday, November 23, 2010 8:05:40 AM



Page 1

Item ID:	D4030-041	Accept		Setup	Start	
Revisor ID:						
Item Name:	Long Basket Assembly (350)				Stop	
Start Date:	11/23/2010	Start Qty:	1.00			
Required Date:	11/30/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10-11-23	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4030	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

8/10/12/20

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




**Work Order ID 64024**

Tuesday, November 23, 2010 8:05:40 AM

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Item ID: D4030-041 Accept  Setup Start   
Revision ID:   
Item Name: Long Basket Assembly (350) Stop   
Start Date: 11/23/2010 Start Qty: 1.00  Cust Item ID:   
Required Date: 11/30/2010 Req'd Qty: 1.00  Customer:   
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00		64 023		0/12/20			
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							10/12/2010 MK 10-12-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Work Order ID: 64024

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)






Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as  
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg  
revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	2.0000	1	1			
<div> <div>Location</div> <div>ST506</div> <div>61224</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2535  Spring		Manufactured	No			100	Each	52.0000	2	2			
<div> <div>Location</div> <div>ST504</div> <div>58331</div> </div> <div> <div>Loc Qty</div> <div>52</div> <div>52</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2537  Bushing		Manufactured	No			100	Each	34.0000	2	2			
<div> <div>Location</div> <div>ST504</div> <div>59423</div> <div>62393</div> </div> <div> <div>Loc Qty</div> <div>34</div> <div>4</div> <div>30</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			

B64026 (K)

B64028 (K)

62946

6

58331

62393

11/30/12/20

11/30/12/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64024



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (L50)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3917-3 Manufactured No

100

Each

21.0000

6

6



Washer



64589

*[Signature]*

Location

Loc Qty

Loc Code

ST095

20

63672

20

ST096

1

57144

1

D3953-3 Manufactured No

100

Each

3.0000

2

2



Gas Spring Stud, Lid



64220

*[Signature]*

Location

Loc Qty

Loc Code

ST101

3

63673

3

D3953-7 Manufactured No

100

Each

4.0000

2

2



Spring Spacer



64207

*[Signature]*

Location

Loc Qty

Loc Code

ST101

3

63674

3

ST103

1

59438

1

D3953-9 Manufactured No

100

Each

4.0000

2

2



Gas Spring Washer



64258 1x

64400 1x

*[Signature]*

Location

Loc Qty

Loc Code

ST101

2

63675

2

ST103

2

60008

2

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 64024

Parent Item: D4030-041

Parent Iter. Name: Long Basket Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3953-17 Manufactured No

100 Each

3.0000

2 2



Gas Spring Spacer

Location

Loc Qty

Loc Code

ST101

3

57143

1

59197

2



64024

*[Signature]*

D3953-19 Manufactured No

100 Each

8.0000

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ST

8

59213

8



1 ✓

*[Signature]*

D3953-21 Manufactured No

100 Each

16.0000

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ENG

5

56407

5

ST102

11

57145

2

59214

9



59213

1 ✓

*[Signature]*

D3969-3 Manufactured No

100 Each

5.0000

1



Spring (Basket Lid)

Location

Loc Qty

Loc Code

ST

1

58986

1

ST272

4

63657

4



59214

1 ✓

*[Signature]*

63657

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, November 23, 2010 8:05:44 AM

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Work Order ID: 64024

Parent Item: D4030-041

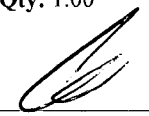
Parent Item Name: Long Basket Assembly (350)


Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00


Required Qty: 1.00


AN3-14A Purchased No 100 Each 92.0000 4 4 ✓ 

 Bolt

Location	Loc Qty	Loc Code
ST351	92	
114941	42	
115108	50	


11/4941


AN3-16A Purchased No 100 Each 80.0000 2 2 ✓ 

 Bolt

Location	Loc Qty	Loc Code
ST352	80	
114752	80	

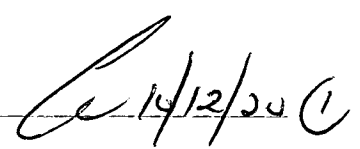
11/4752


AN5-17A Purchased No 100 Each 102.0000 4 4 ✓ 

 Bolt

Location	Loc Qty	Loc Code
ST339	102	
114784	12	
115594	40	
116003	50	

11/5594

AN4-12 Purchased No 100 Each 25.0000 3 3 ✓ 

 Bolt

Location	Loc Qty	Loc Code
ST357	25	
114292	2	
114784	23	

11/4784

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64024

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN310-4 Purchased No

100 Each

72.0000

3

3



NUT

Location

Loc Qty

Loc Code

ST324

72

115107

2

115936

20

116075

50



116075  
2

AN310C4 Purchased No

100 Each

30.0000

2



Nut

Location

Loc Qty

Loc Code

ST349

30

114306

30



114306  
6

MS21042L3 Purchased No

100 Each

1,627.000

6



Nut

Location

Loc Qty

Loc Code

ST300

1627

114784

631

115835

996



115835

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 23, 2010 8:05:44 AM

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Work Order ID: 64024

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

1,363.000

4

4



Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1337

115156

137

115594

500

116104

200

116105

500

MS24665-151

Purchased

No

100

Each

600.0000

3

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

600

17566

600

MS24665-300

Purchased

No

100

Each

44.0000

2

2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

44

105279

2

110123

42

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, November 23, 2010 8:05:44 AM

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Work Order ID: 64024

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

250.0000

6



Washer



6 ~  
M116391

*[Signature]*

Location

Loc Qty

Loc Code

ST275

250

112940

92

114405

1

114576

10

114718

2

116169

145

NAS1149F0563P

Purchased

No

100

Each

180.0000

4



Washer



4 ✓

*[Signature]*

Location

Loc Qty

Loc Code

ST275

2

108471

2

ST298

178

114576

178

NAS1149F0332P

Purchased

No

100

Each

463.0000

8



WASHER



M114576  
8

*[Signature]*

Location

Loc Qty

Loc Code

ST275

463

18057

463

NAS1149C0432R

Purchased

No

100

Each

378.0000

2



Washer



18057  
2

*[Signature]*

Location

Loc Qty

Loc Code

ST297

378

114292

50

114742

328

114742

Tuesday, November 23, 2010 8:05:44 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

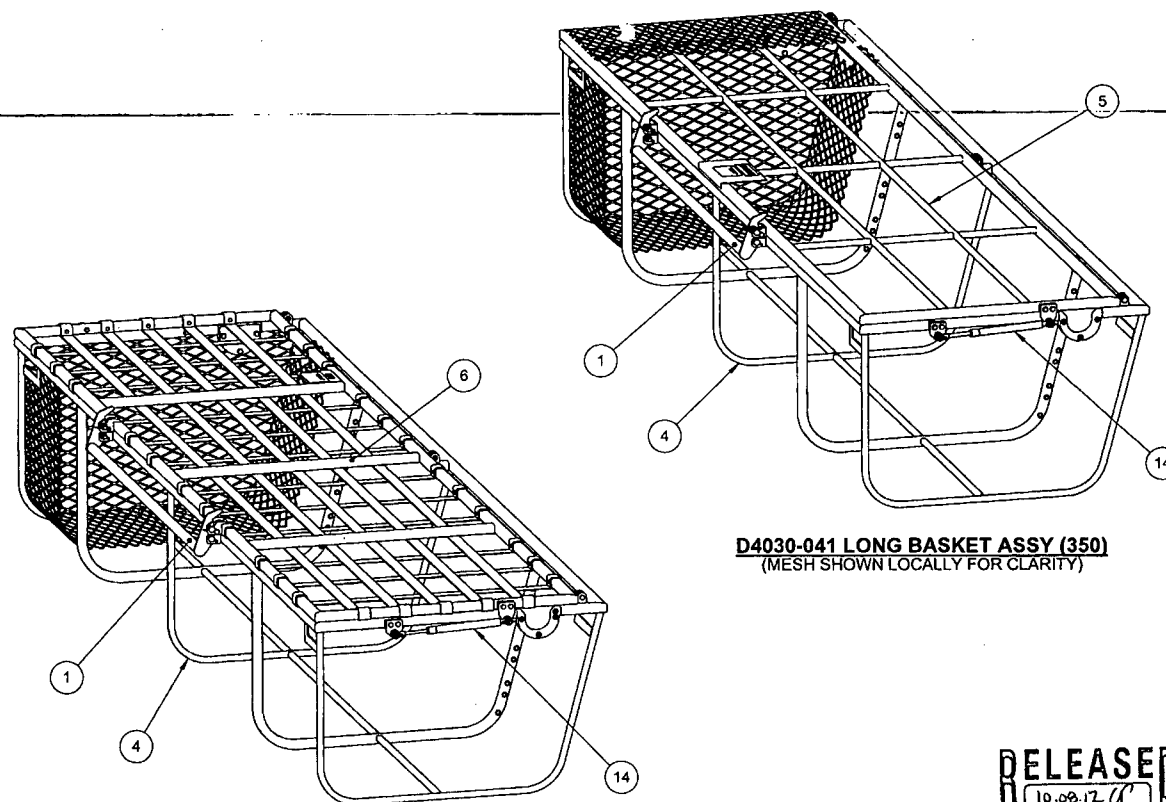
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	4	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



**D4030-041 LONG BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D4030-043 LONG BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: -041: 72 lbs APPROX  
-043: 57 lbs APPROX

SHO  
RET  
ENGINEER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER 4  
NO. 64024

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JFS		
APPROVED	JP		
DE APPR.	JP		
DATE	10.07.23		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4030</b>	REV. C
TITLE <b>LONG BASKET ASSY (350)</b>	SHEET 1 OF 3
SCALE NTS	
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED  
10-08-12  
ECN 10-596

10-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

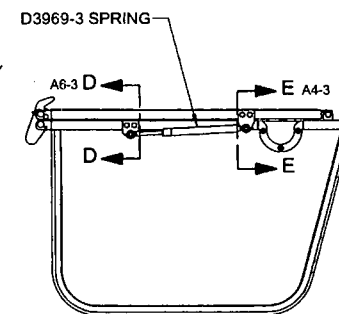
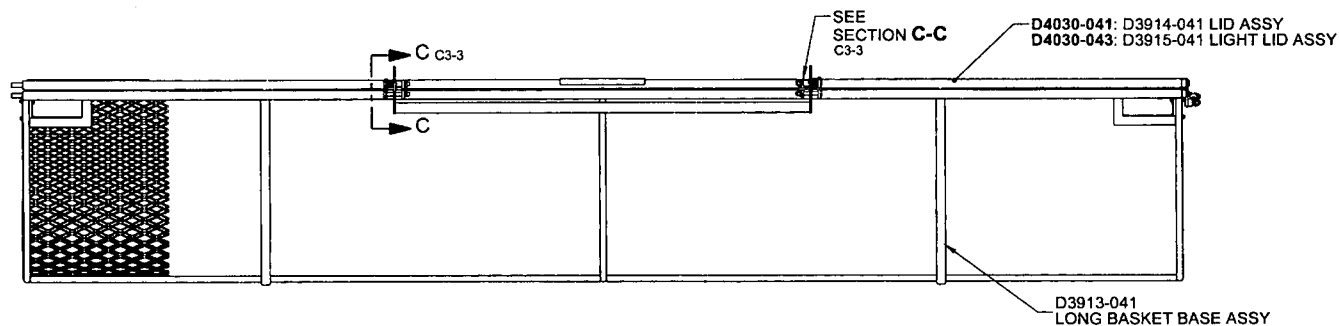
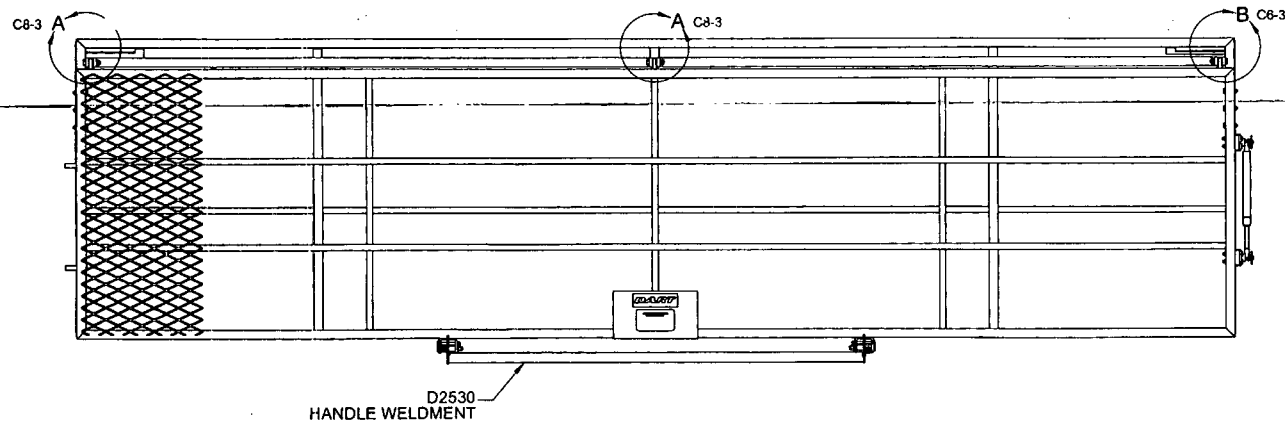
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D4030-041 LONG BASKET ASSY (350)** (SHOWN)  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

**D4030-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SE	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS.
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
10.08.24

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

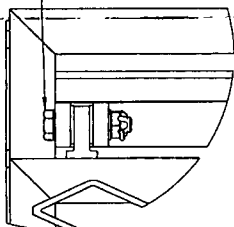
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

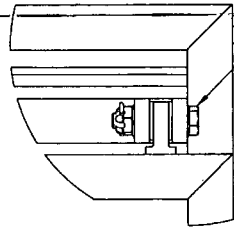
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



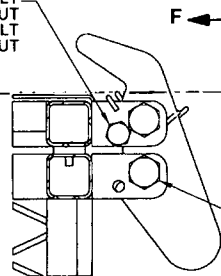
**DETAIL A** D8-2  
D5-2



**DETAIL B** D3-2

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN

D4030-041: AN3-16A BOLT  
MS21042L3 NUT  
D4030-043: AN3-20A BOLT  
MS21042L3 NUT

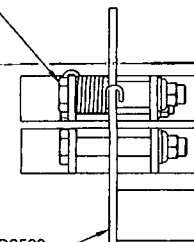


**SECTION C-C** B4-2  
B6-2

D4030-041: AN5-17A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

D4030-043: AN5-21A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

AN5-17A BOLT  
NAS1149F0563P WASHER  
MS21042L5 NUT



D2530  
HANDLE WELDMENT  
REF

**VIEW F-F** C3-3

D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET  
AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION D-D** B2-2

D3953-17 GAS SPRING SPACER  
D3953-19 GAS SPRING BRACKET  
AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION E-E** B1-2

*u1064024*

**RELEASED**  
10.08.17 4

DESIGN	A.S.	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	J.F.S. B.T.M.	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries